

# Work Order ID 86205

**\*86205\***

Page 1

June-22-12 3:04:30 PM

Item ID: D4074-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 22/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/22 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: 12/06/22 SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4074

C

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

6061 .125

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-6-26

B12-6-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 86205

**\*86205\***

Page 3

Item ID: D4074-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 22/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

16 MA 12.73

160 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*160\***

Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

10:30  
320°F  
11:00

16X ✓ MA  
12/07/04

170 QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

16 ✓ BLD.7H.

m1214841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*86205\***

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Item ID: D4074-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 22/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180 Identify as per dwg & Stock Location: 091

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

16 12/07/04 JB

190 QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12/17/04

ME  
12-07-04

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-22-12 3:04:34 PM

Page 1

Work Order ID: 86205

\*86205\*

Parent Item: D4074-1

\*D4074-1\*

Parent Item Name: Bracket

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC  
AS PER ECN 11-613 11-07-25 JLM VERIFIED BY:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	44.2745	0.0452	0.475789	1,		

\*M6061T6S 125\*

6061-T6 .125 Sheet

\*\*

B12-G-XC

### Location

### Loc Qty

### Loc Code

MAT021

44.2745

121473

44.2745

121473

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



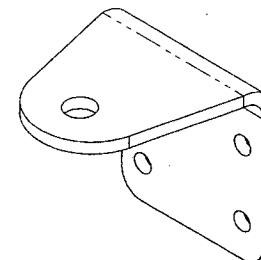
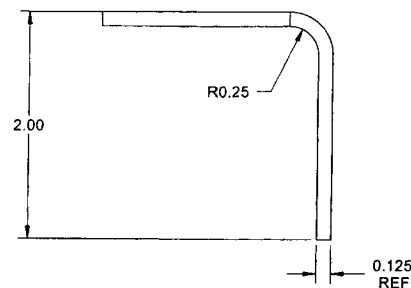
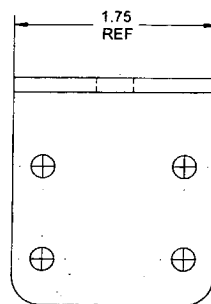
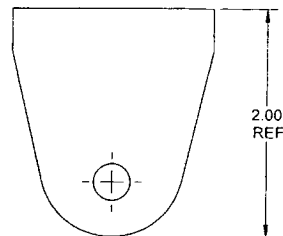
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 80205 MLJ

12/06/22

RELEASED  
2011-10-28  
JMH

**D4074-1 BRACKET**  
(MAKE FROM D4074-1F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

C	MODIFY -7 STRIKER PLATE, SHEET 6 AND 7	HS	11.10.12
B	Ø 0.173 WAS Ø 0.129 (ZN B3-4); 1.28 WAS 0.90 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. <b>D4074</b> SHEET 1 OF 7 TITLE <b>BRACKET</b> SCALE NTS DATE <b>11.10.12</b>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.10.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

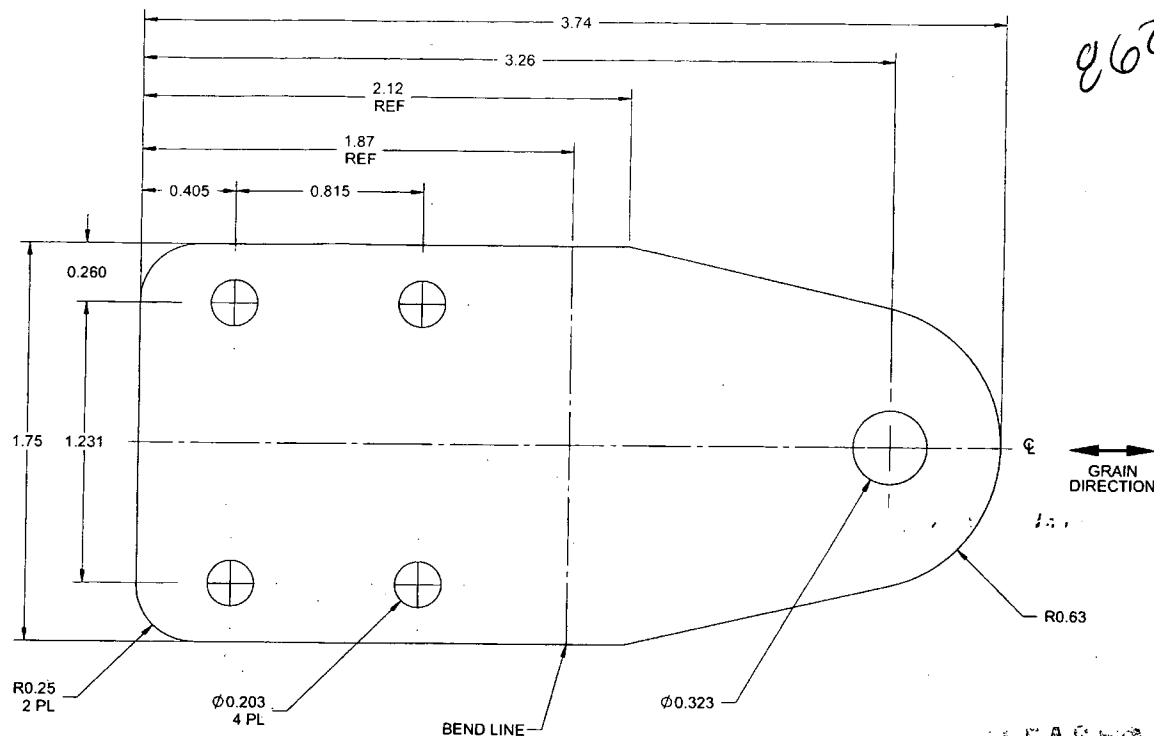
4

3

2

1

86205

0.125  
REF**D4074-1F FLAT PATTERN****NOTES:**

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK  
 PER QQ-A-250/11 OR AMS-QQ-A-250/11  
 OR AMS 4025 OR AMS 4027  
 OR ASTM B209  
 REF DART SPEC M6061T6S.125

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.07 lbs

8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED  
 2011-10-26  
 ANP

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 2 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

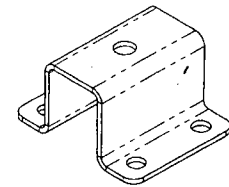
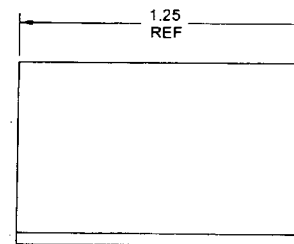
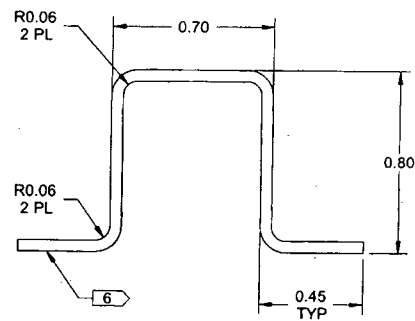
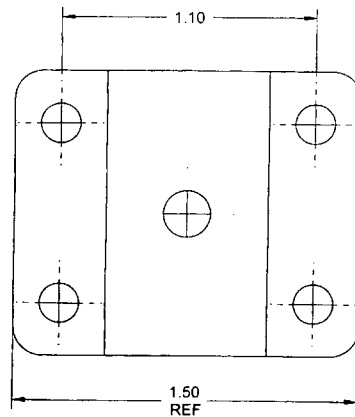
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





86205

**D4074-3 CHANNEL**  
(MAKE FROM D4074-3F FLAT PATTERN)

RELEASED  
2011-10-26  
JMP

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 3 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
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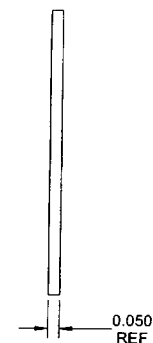
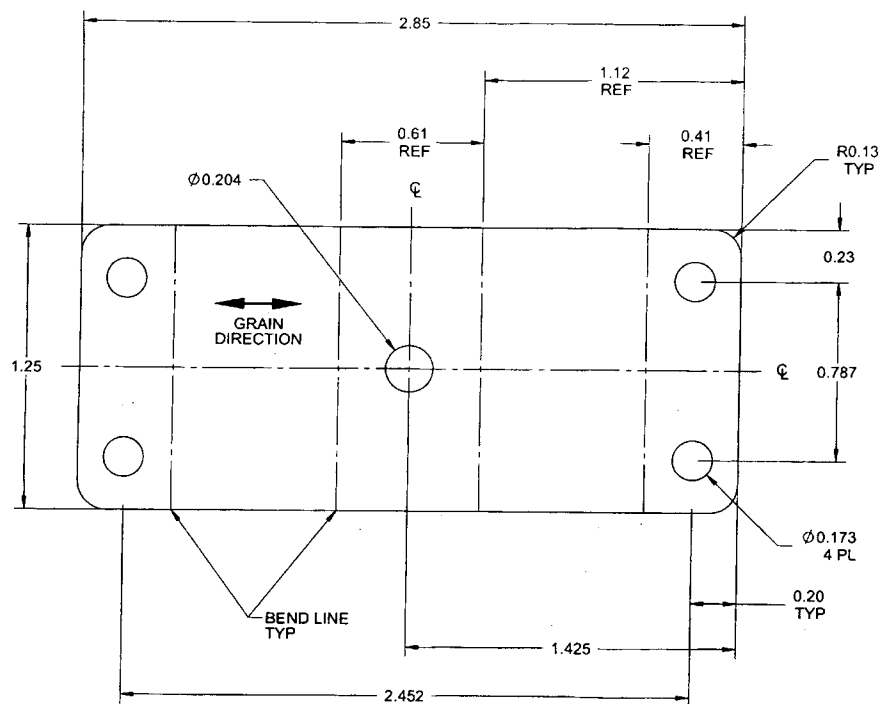
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






**NOTE:** Date & initial all entries



# NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH  
0.050 (18 GAUGE) THICK  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
REF DART SPEC M3046S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

## **D4074-3F FLAT PATTERN**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4074</b>	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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2011-10-26

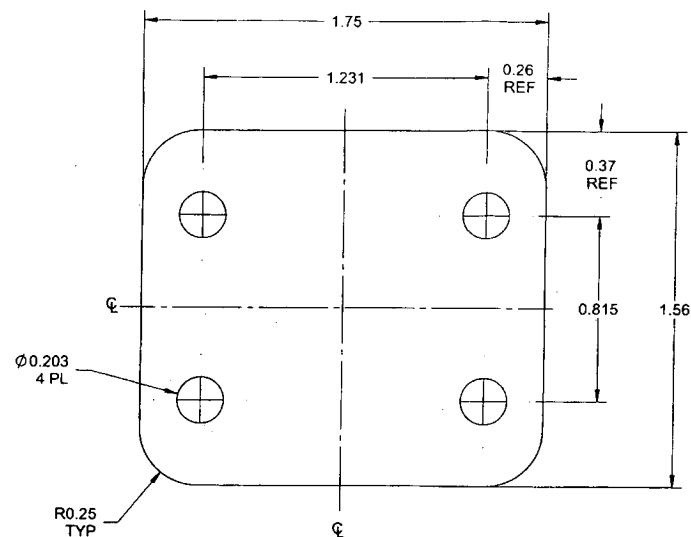
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4074-5 BACKING PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	<b>D4074</b>	SHEET 5 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>BRACKET</b>	NTS
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2011-10-26  
RF

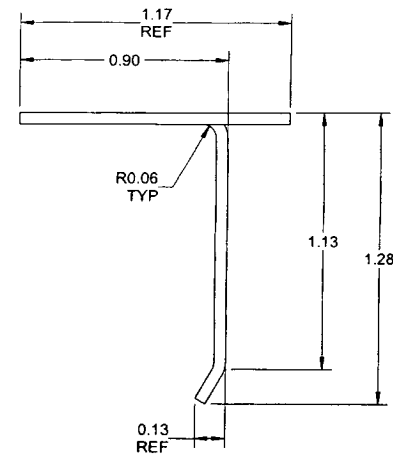
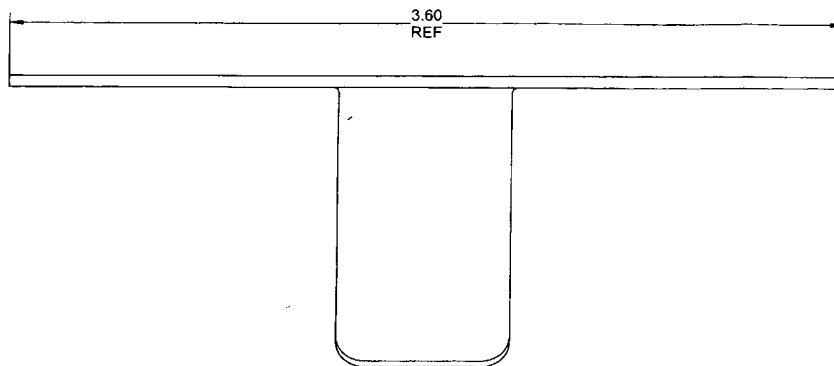
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



96205

**D4074-7 STRIKER PLATE**  
(MAKE FROM D4074-7F FLAT PATTERN)

RELEASED  
2011-10-26

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-7F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 6 OF 7
APPROVED	RF	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

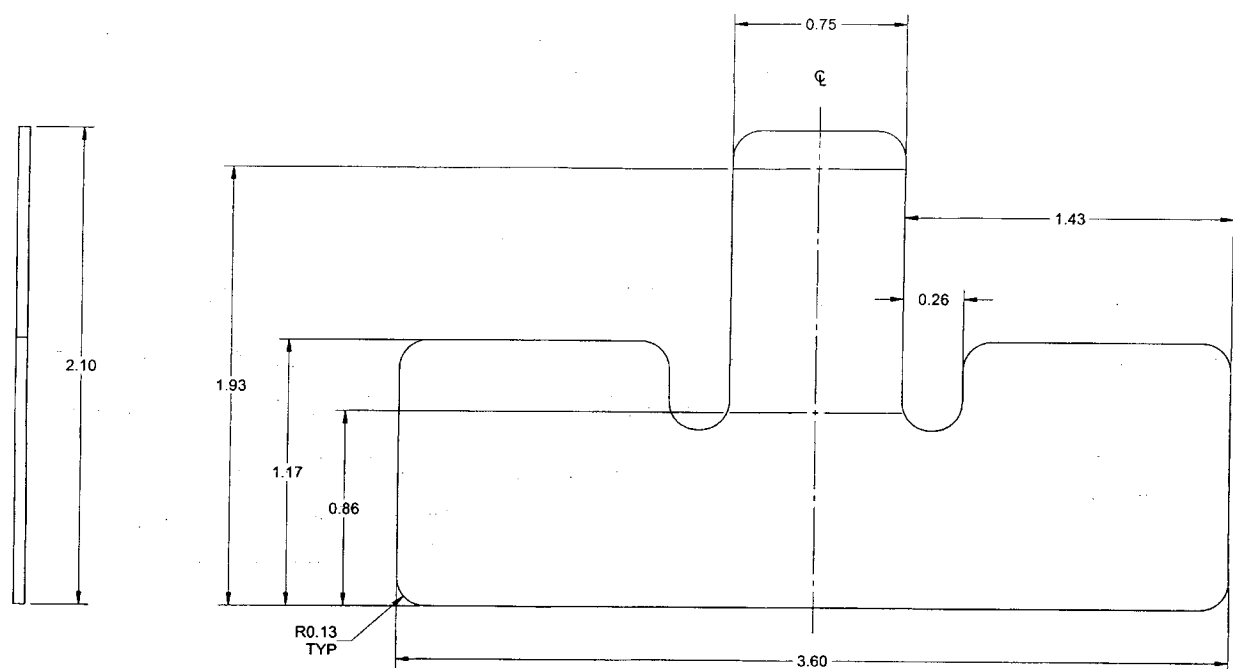
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries








86205



**D4074-7F FLAT PATTERN**

2011-10-26

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH  
0.050 (18 GAUGE) THICK  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
REF DART SPEC M3046S18GA
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.01 lbs
  - 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4074	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.10.12	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries